

Date: Thursday, 17/04/2008 10:59:21 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 205 SKIDTUBE "I" BEAM						
Job Number	: 38660									
Estimate Number	: 10346									
P.O. Number	:			Part Number	: D2596					
This Issue	: 17/04/2008	S.O. No.	:			Drawing Number	: D2596 REV D			
Prsht Rev.	: NC					Project Number	: N/A			
First Issue	: / /		Type	: LANDING GEAR			Drawing Revision	: D		
Previous Run	: 38642			Material	:					
Written By	:			Due Date	: 28/04/2008			Qty:	4	
Checked & Approved By	: <u>JLD 08.4.17</u>			Um:	Each					
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D			M						
				Est Rev:E 07-07-09 Incorporated DEO 9183 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D25003100	Extrn - I Beam Web 4"	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion <u>B33940</u> <u>JD 8-4-18</u>			
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" 2- Use Jig DT8093 to drill pilot holes #30 3- Open to 0.630" diameter as per Dwg D2596 4- Deburr			
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 <u>JD 8-4-18</u>			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP <u>DP 8-4-21</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Skid tube cell</u> <u>DP</u> <u>8-4-21</u> <u>(4)</u>		
6.0	QC21 	FINAL INSPECTION/W/O RELEASE  <u>08/04/22</u>
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion  <u>U 08-04-22</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

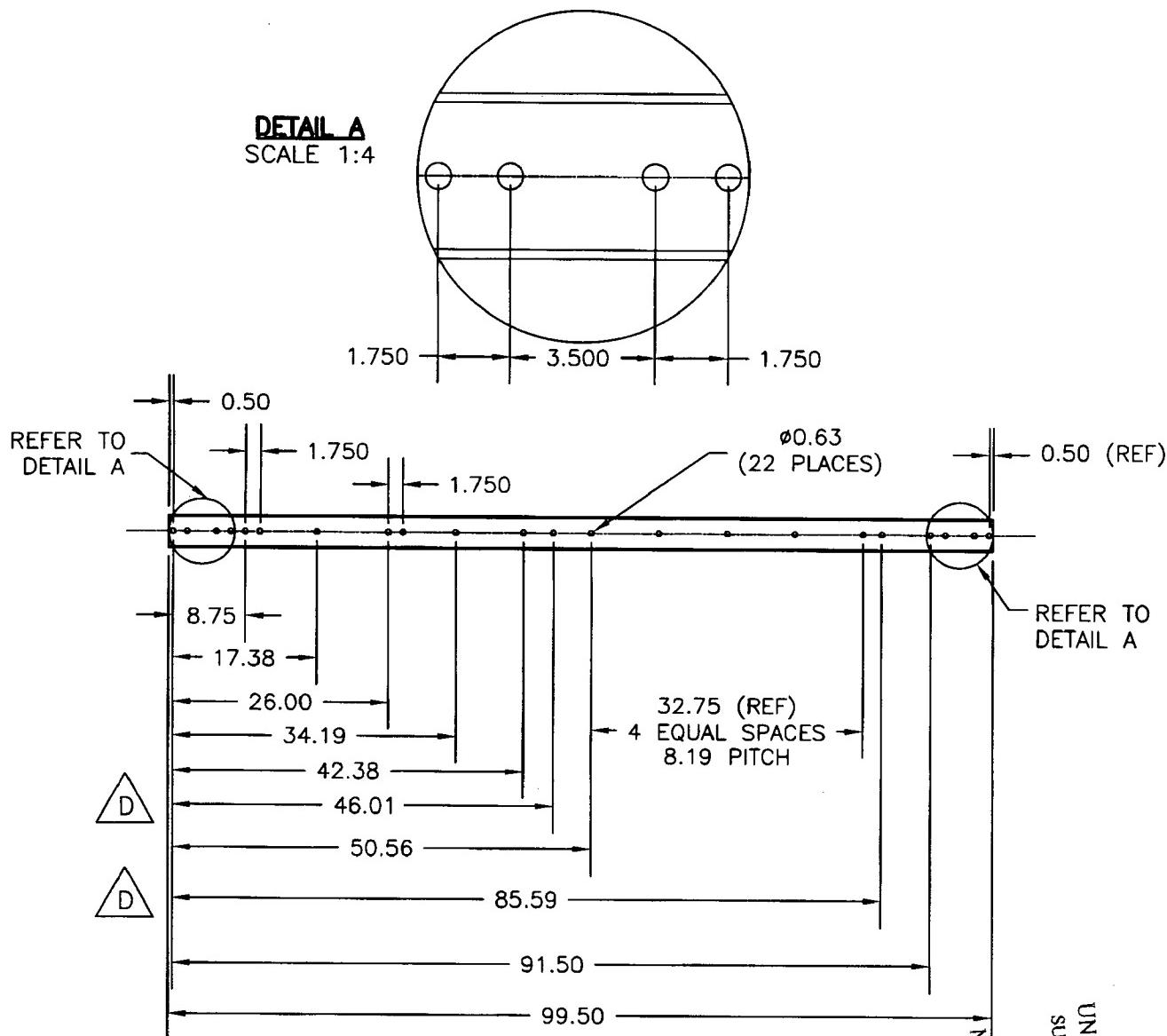
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
R 07-04-18

DESIGN <i>RH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD	
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D2596	REV. D SHEET 1 OF 1
DATE 07.04.17	TITLE 205 WEB	SCALE 1:20	
A B C D	96.09.16 97.07.23 98.09.14 07.04.17	NEW ISSUE φ0.63 HOLE WAS φ0.56 INCORPORATED DEO 9097 INCORPORATED DEO 9183	

**D2596 WEB**

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38640